

SPECIFICATION
 FOR THE
 PROCUREMENT AND ASSEMBLY
 OF
 ELECTRICAL WRAPOST CONTACTS AND INSULATORS

SPECIFICATION FOR THE PROCUREMENT AND ASSEMBLY
 OF
 ELECTRICAL WRAPOST CONTACTS AND INSULATORS

The purpose of this document is to establish the requirements for the procurement and assembly of wra-post contacts and insulators for use in Apollo Guidance and Navigation Equipment.

1. SCOPE

1.1 SCOPE. This specification covers procurement and assembly requirements for wra-post contacts and insulators comprised of male and/or female contacts, their respective insulators, and their mounting structures or metal insert plates. The wra-post contacts and insulators shall be hereinafter referred to as connectors or connector assemblies.

1.2 CLASSIFICATION. Connector assemblies shall have two configurations:

a. Those which are lined up on a 0.200 inch grid configuration, hereinafter referred to as Type A.

b. Those which are lined up on a 0.125 inch grid configuration, hereinafter referred to as Type B.

2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on the date of invitation for bids shall form a part of this specification to the extent specified herein.

SPECIFICATIONS

Federal

QQ-M-31
 QQ-A-561

Magnesium Alloy
 Aluminum Alloy
 Plate and Sheet, 1100

Military

MIL-M-3171

Anodic Coating for Magnesium
 and Magnesium Alloys

MIL-A-8625

Anodic Coating for Aluminum and
 Aluminum Alloys

MIL-E-17555

Electronic and Electrical Equipment
 and Associated Repair Parts, Preparation
 for Delivery of

Apollo G & N
 ND-1015404

General Specification Configuration, Process
 and Quality Control Requirements for Suppliers
 of High Reliability Articles for Use in Space-
 craft and Supporting Equipment

Revision Letter	TDRR No.	Pages Revised	Approvals		Date
			MIT	NASA	

This specification consists of
 pages 1 to 111 and 1 to 112 inclusive

Walker Taylor 12 Sep 63
 MIT INSTRUMENTATION LABORATORY

William L. Swartz 12 Sept 1963
 NASA/NSC APPROVAL

Apollo G & N Specification
ND-1002136
12 Sept. 1963
Class A Release
TDRR 0306Z
REV A TDRR 10816
7 July 1964

SPECIFICATION

FOR THE

REQUIREMENT

OF

ELECTRICAL WRAPOST CONTACTS AND INSULATORS

SPECIFICATION FOR THE REQUIREMENT
OF
ELECTRICAL WRAPOST CONTACTS AND INSULATORS

The purpose of this document is to establish the requirements for the assembly of wrapost contacts and insulators for use in Apollo Guidance and Navigation Equipment.

Apollo G & N Specification
ND-1002136
12 Sept. 1963

1. SCOPE

1.1 SCOPE. This specification covers assembly requirements for wrapost contacts, and insulators comprised of male and/or female contacts, their respective insulators, and their mounting structures on metal insert plates. The wrapost contacts and insulators shall be hereinafter referred to as connectors or connector assemblies.

1.2 CLASSIFICATION. Connector assemblies shall have two configurations:

- Those which are lined up on a 0.200 inch grid configuration, hereinafter referred to as Type A. These assemblies consist of contact blade (1010382) and insulator male (1010383) or contact female (1010379) and insulator female (1010380).
- Those which are lined up on a 0.125 inch grid configuration, hereinafter referred to as Type B. These assemblies consist of contact, 0.020 blade (1006782) and insulator, male, mini (1006775) or contact, female, mini (1006781) and insulator, female mini (1006774).

2. APPLICABLE DOCUMENTS

2.1 The following documents of the issue in effect on the date of invitation for bids shall form a part of this specification to the extent specified herein.

SPECIFICATIONS

Apollo G & N
ND-1315404

General Specification Configuration, Process and Quality Control Requirements for Suppliers of High Reliability Articles for Use in Spacecraft and Supporting Equipment.

ND-1002004

Epoxy Bonding

Revision Letter	TDRR No.	Pages Revised	Approval		Date
			MIT	NASA	
A	10816	iii Page 1, 3, 4, 5, 10, 11, 12, 14, 15, 16, 18, 19	WK	WHS	12 Sept 1963

This specification consists of pages 1 to iii and 1 to 18, inclusive

Walker Lytle 12 Sep 63
MIT INSTRUMENTATION LABORATORY

William L. Swartz 12 Sept 1963
NASA/MSC APPROVAL

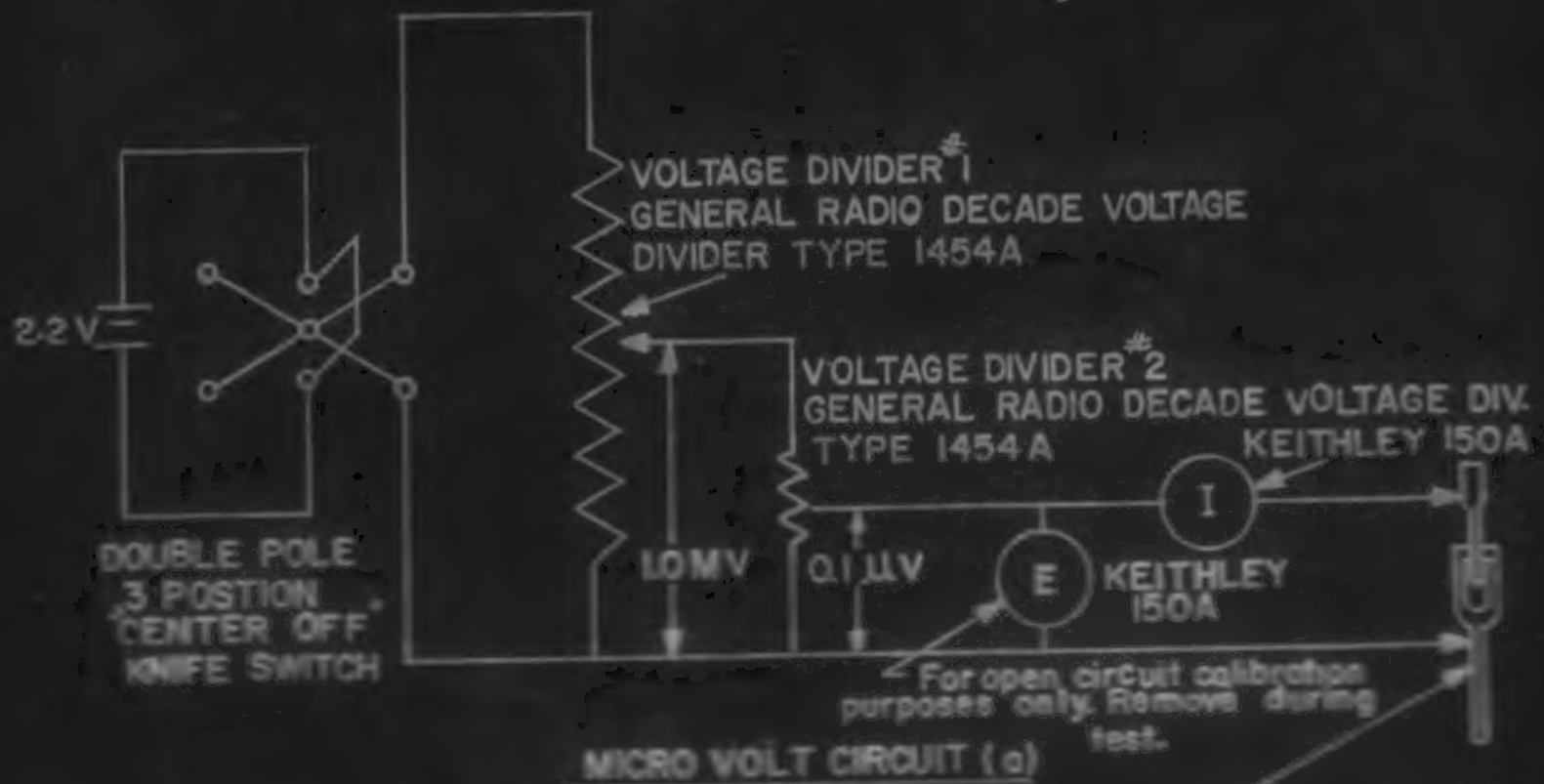
12 Sept, 1963

SPECIFICATION FOR THE ASSEMBLY
OF
ELECTRICAL WRAPOST CONTACTS AND INSULATORS

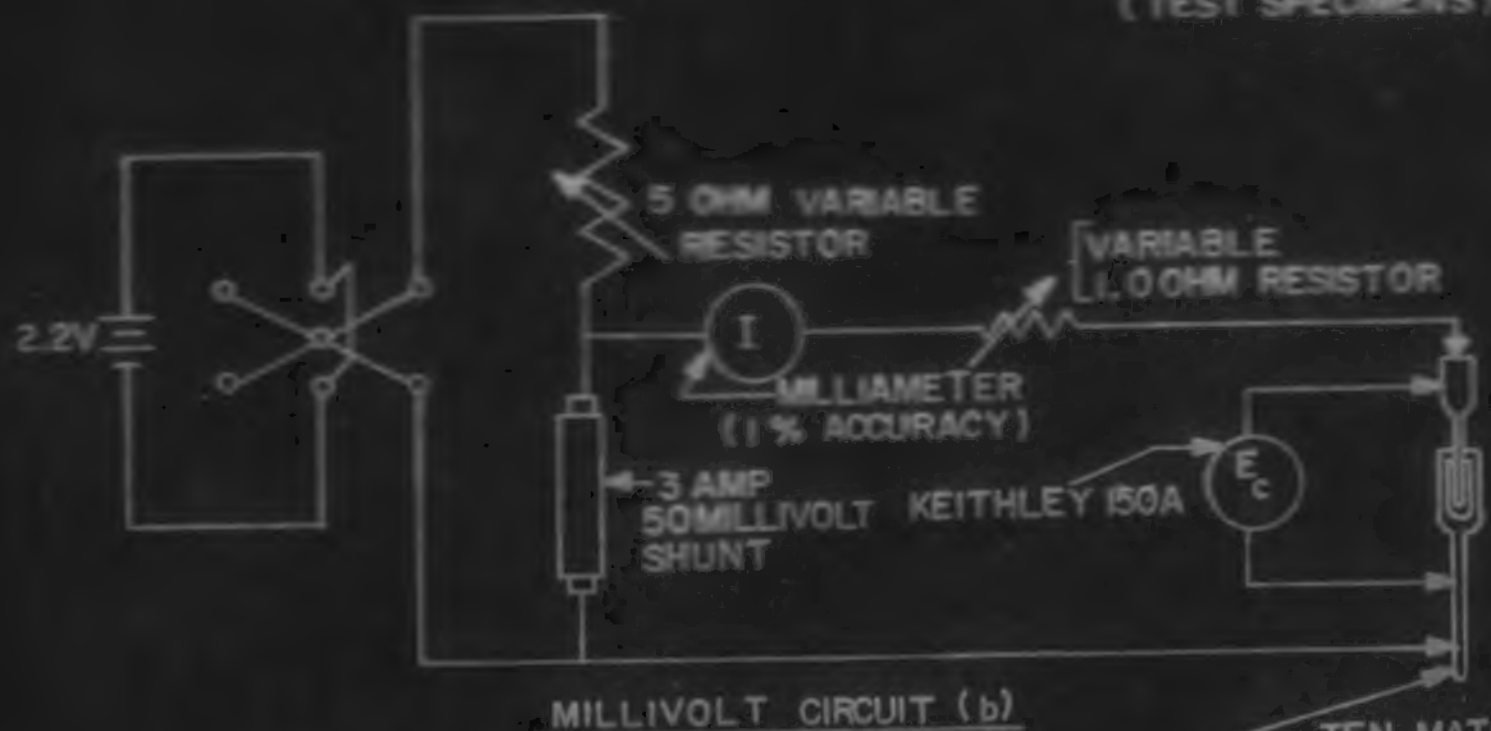
The purpose of this document is to establish the requirements for the assembly of wrapost contacts and insulators for use in Apollo Guidance and Navigation Equipment.

Walter Taylor 12 Sep 63

William L. Swift 12 Sept 1963



TEN MATED CONTACTS IN SERIES. (TEST SPECIMENS)



TEN MATED CONTACTS IN SERIES. (TEST SPECIMENS)

FIGURE 2 DRY CIRCUIT TEST DIAGRAM



FIGURE 1 TEST SET UP FOR MEASURING MATED CONTACT
RESISTANCE



MALE TYPE	DIMENSION (INCHES)				
	A	B	C	D	E
A	20.4 REF	0.80 ± 0.05	0.42 REF	0.62 ± 0.05	1.5 ± 0.05
B	20.4 REF	0.80 ± 0.05	0.42 REF	0.62 ± 0.05	1.5 ± 0.05 VARIABLE

ASSEMBLY



FEMALE TYPE	DIMENSION (INCHES)				
	A	B	C	D	E
A	338 REF.	347 \pm 005	188 \pm 010	VARIABLE	
B	200 REF.	080 \pm 005	210 \pm 005	113 \pm 005	VARIABLE

ASSEMBLY

1. The first part of the document is a letter from the President of the United States to the Congress, dated January 3, 1801. It contains a report on the state of the Union and the progress of the government during the year 1800.

2. The second part of the document is a report from the Secretary of the Treasury, dated January 3, 1801. It contains a detailed account of the financial state of the government and the measures taken to improve it.

3. The third part of the document is a report from the Secretary of the Navy, dated January 3, 1801. It contains a detailed account of the naval operations and the state of the fleet.

4. The fourth part of the document is a report from the Secretary of the War, dated January 3, 1801. It contains a detailed account of the military operations and the state of the army.

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JOURNAL
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ROYAL ANTHROPOLOGICAL INSTITUTE
OF GREAT BRITAIN AND IRELAND
VOLUME 34
PART 1
1904

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VOLUME 34
PART 1
1904

1.3.1.1

1.3.1.2

that the production will

1.3.1.3

1. The first part of the document is a list of names and addresses of the members of the committee.

2. The second part is a list of the names and addresses of the members of the committee who have been elected to the office of the chairperson.

3. The third part is a list of the names and addresses of the members of the committee who have been elected to the office of the secretary.

4. The fourth part is a list of the names and addresses of the members of the committee who have been elected to the office of the treasurer.

5. The fifth part is a list of the names and addresses of the members of the committee who have been elected to the office of the clerk.

6. The sixth part is a list of the names and addresses of the members of the committee who have been elected to the office of the assistant clerk.

7. The seventh part is a list of the names and addresses of the members of the committee who have been elected to the office of the assistant treasurer.

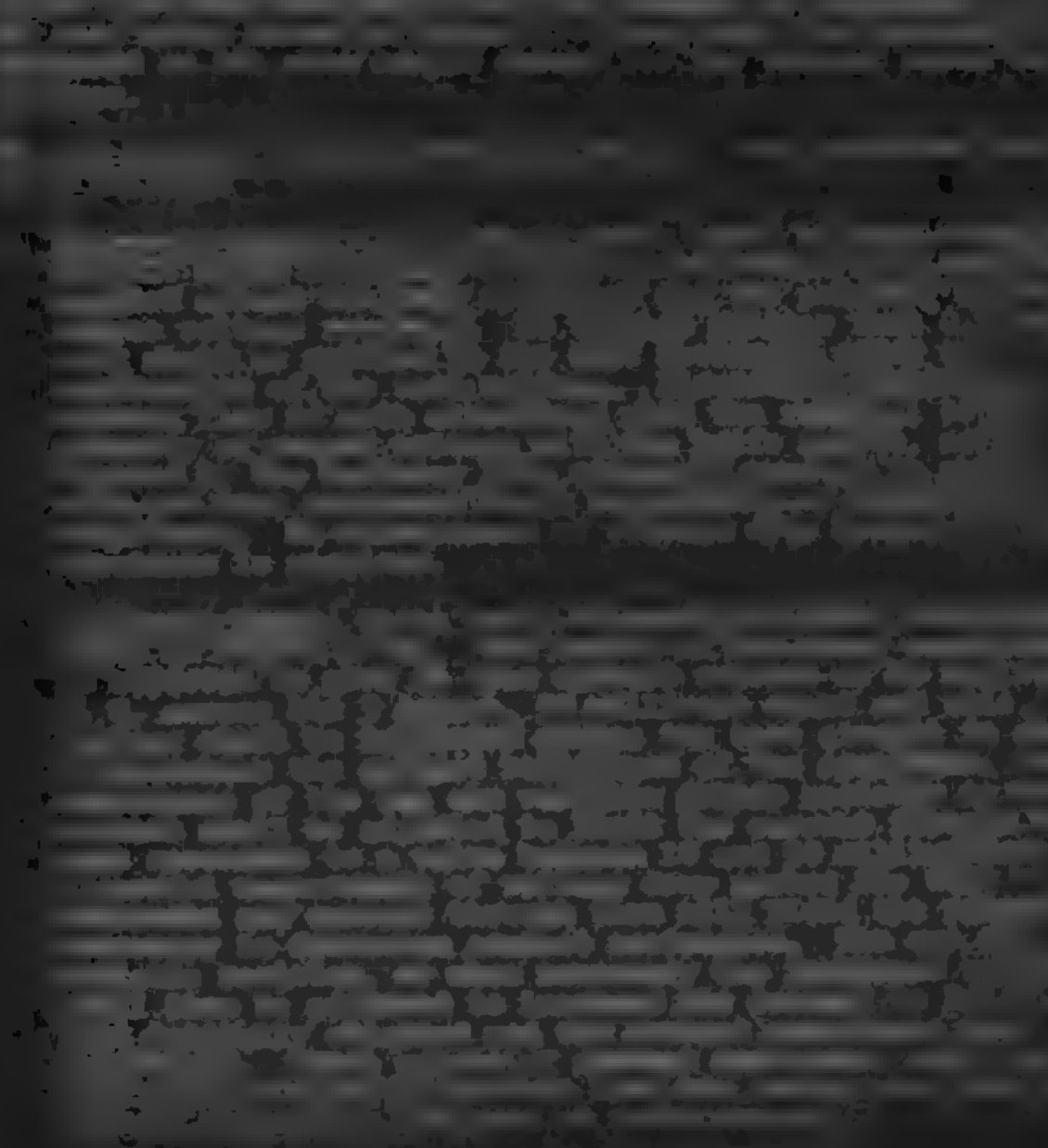
8. The eighth part is a list of the names and addresses of the members of the committee who have been elected to the office of the assistant secretary.

407 thru 460

1.1.1.1

1.1.1.1

1.1.1.1



Class A Roll

[illegible]

1. CLASSIFICATION. Connector assemblies governed by

- c. Those which are aligned on a 0.125 grid co-ordinates shall be referred to as Type F
- Those which are aligned on a 0.250 grid shall be referred to as Type G

ed to as Type F

100677-

3.3.1.8 Type H.





- a. Acceptance Tests
- b. Process Control Tests

4.4 INSPECTION AND TEST SAMPLES

(ot shall)

1	2	3	4	5	6

1997, 1998, 1999, 2000, 2001, 2002, 2003, 2004, 2005, 2006, 2007, 2008, 2009, 2010, 2011, 2012, 2013, 2014, 2015, 2016, 2017, 2018, 2019, 2020, 2021, 2022, 2023, 2024, 2025, 2026, 2027, 2028, 2029, 2030, 2031, 2032, 2033, 2034, 2035, 2036, 2037, 2038, 2039, 2040, 2041, 2042, 2043, 2044, 2045, 2046, 2047, 2048, 2049, 2050, 2051, 2052, 2053, 2054, 2055, 2056, 2057, 2058, 2059, 2060, 2061, 2062, 2063, 2064, 2065, 2066, 2067, 2068, 2069, 2070, 2071, 2072, 2073, 2074, 2075, 2076, 2077, 2078, 2079, 2080, 2081, 2082, 2083, 2084, 2085, 2086, 2087, 2088, 2089, 2090, 2091, 2092, 2093, 2094, 2095, 2096, 2097, 2098, 2099, 2100, 2101, 2102, 2103, 2104, 2105, 2106, 2107, 2108, 2109, 2110, 2111, 2112, 2113, 2114, 2115, 2116, 2117, 2118, 2119, 2120, 2121, 2122, 2123, 2124, 2125, 2126, 2127, 2128, 2129, 2130, 2131, 2132, 2133, 2134, 2135, 2136, 2137, 2138, 2139, 2140, 2141, 2142, 2143, 2144, 2145, 2146, 2147, 2148, 2149, 2150, 2151, 2152, 2153, 2154, 2155, 2156, 2157, 2158, 2159, 2160, 2161, 2162, 2163, 2164, 2165, 2166, 2167, 2168, 2169, 2170, 2171, 2172, 2173, 2174, 2175, 2176, 2177, 2178, 2179, 2180, 2181, 2182, 2183, 2184, 2185, 2186, 2187, 2188, 2189, 2190, 2191, 2192, 2193, 2194, 2195, 2196, 2197, 2198, 2199, 2200, 2201, 2202, 2203, 2204, 2205, 2206, 2207, 2208, 2209, 2210, 2211, 2212, 2213, 2214, 2215, 2216, 2217, 2218, 2219, 2220, 2221, 2222, 2223, 2224, 2225, 2226, 2227, 2228, 2229, 2230, 2231, 2232, 2233, 2234, 2235, 2236, 2237, 2238, 2239, 2240, 2241, 2242, 2243, 2244, 2245, 2246, 2247, 2248, 2249, 2250, 2251, 2252, 2253, 2254, 2255, 2256, 2257, 2258, 2259, 2260, 2261, 2262, 2263, 2264, 2265, 2266, 2267, 2268, 2269, 2270, 2271, 2272, 2273, 2274, 2275, 2276, 2277, 2278, 2279, 2280, 2281, 2282, 2283, 2284, 2285, 2286, 2287, 2288, 2289, 2290, 2291, 2292, 2293, 2294, 2295, 2296, 2297, 2298, 2299, 2300, 2301, 2302, 2303, 2304, 2305, 2306, 2307, 2308, 2309, 2310, 2311, 2312, 2313, 2314, 2315, 2316, 2317, 2318, 2319, 2320, 2321, 2322, 2323, 2324, 2325, 2326, 2327, 2328, 2329, 2330, 2331, 2332, 2333, 2334, 2335, 2336, 2337, 2338, 2339, 2340, 2341, 2342, 2343, 2344, 2345, 2346, 2347, 2348, 2349, 2350, 2351, 2352, 2353, 2354, 2355, 2356, 2357, 2358, 2359, 2360, 2361, 2362, 2363, 2364, 2365, 2366, 2367, 2368, 2369, 2370, 2371, 2372, 2373, 2374, 2375, 2376, 2377, 2378, 2379, 2380, 2381, 2382, 2383, 2384, 2385, 2386, 2387, 2388, 2389, 2390, 2391, 2392, 2393, 2394, 2395, 2396, 2397, 2398, 2399, 2400, 2401, 2402, 2403, 2404, 2405, 2406, 2407, 2408, 2409, 2410, 2411, 2412, 2413, 2414, 2415, 2416, 2417, 2418, 2419, 2420, 2421, 2422, 2423, 2424, 2425, 2426, 2427, 2428, 2429, 2430, 2431, 2432, 2433, 2434, 2435, 2436, 2437, 2438, 2439, 2440, 2441, 2442, 2443, 2444, 2445, 2446, 2447, 2448, 2449, 2450, 2451, 2452, 2453, 2454, 2455, 2456, 2457, 2458, 2459, 2460, 2461, 2462, 2463, 2464, 2465, 2466, 2467, 2468, 2469, 2470, 2471, 2472, 2473, 2474, 2475, 2476, 2477, 2478, 2479, 2480, 2481, 2482, 2483, 2484, 2485, 2486, 2487, 2488, 2489, 2490, 2491, 2492, 2493, 2494, 2495, 2496, 2497, 2498, 2499, 2500, 2501, 2502, 2503, 2504, 2505, 2506, 2507, 2508, 2509, 2510, 2511, 2512, 2513, 2514, 2515, 2516, 2517, 2518, 2519, 2520, 2521, 2522, 2523, 2524, 2525, 2526, 2527, 2528, 2529, 2530, 2531, 2532, 2533, 2534, 2535, 2536, 2537, 2538, 2539, 2540, 2541, 2542, 2543, 2544, 2545, 2546, 2547, 2548, 2549, 2550, 2551, 2552, 2553, 2554, 2555, 2556, 2557, 2558, 2559, 2560, 2561, 2562, 2563, 2564, 2565, 2566, 2567, 2568, 2569, 2570, 2571, 2572, 2573, 2574, 2575, 2576, 2577, 2578, 2579, 2580, 2581, 2582, 2583, 2584, 2585, 2586, 2587, 2588, 2589, 2590, 2591, 2592, 2593, 2594, 2595, 2596, 2597, 2598, 2599, 2600, 2601, 2602, 2603, 2604, 2605, 2606, 2607, 2608, 2609, 2610, 2611, 2612, 2613, 2614, 2615, 2616, 2617, 2618, 2619, 2620, 2621, 2622, 2623, 2624, 2625, 2626, 2627, 2628, 2629, 2630, 2631, 2632, 2633, 2634, 2635, 2636, 2637, 2638, 2639, 2640, 2641, 2642, 2643, 2644, 2645, 2646, 2647, 2648, 2649, 2650, 2651, 2652, 2653, 2654, 2655, 2656, 2657, 2658, 2659, 2660, 2661, 2662, 2663, 2664, 2665, 2666, 2667, 2668, 2669, 2670, 2671, 2672, 2673, 2674, 2675, 2676, 2677, 2678, 26

NOTES

A dark, high-contrast, black and white image showing a heavily textured, possibly metallic or stone, surface. The texture is characterized by numerous small, irregular pits, scratches, and ridges, giving it a rough, weathered appearance. The lighting is dramatic, with deep shadows and bright highlights that emphasize the surface irregularities. The overall composition is abstract and focuses on the tactile quality of the material.



ITEM	DESCRIPTION	QUANTITY	UNIT	REMARKS
1
2
3

1875-1876
1877-1878
1879-1880



1875-1876	1877-1878	1879-1880	1881-1882	1883-1884	1885-1886	1887-1888	1889-1890	1891-1892	1893-1894	1895-1896	1897-1898	1899-1900	1901-1902	1903-1904	1905-1906	1907-1908	1909-1910	1911-1912	1913-1914	1915-1916	1917-1918	1919-1920	1921-1922	1923-1924	1925-1926	1927-1928	1929-1930	1931-1932	1933-1934	1935-1936	1937-1938	1939-1940	1941-1942	1943-1944	1945-1946	1947-1948	1949-1950	1951-1952	1953-1954	1955-1956	1957-1958	1959-1960	1961-1962	1963-1964	1965-1966	1967-1968	1969-1970	1971-1972	1973-1974	1975-1976	1977-1978	1979-1980	1981-1982	1983-1984	1985-1986	1987-1988	1989-1990	1991-1992	1993-1994	1995-1996	1997-1998	1999-2000	2001-2002	2003-2004	2005-2006	2007-2008	2009-2010	2011-2012	2013-2014	2015-2016	2017-2018	2019-2020	2021-2022	2023-2024	2025-2026	2027-2028	2029-2030	2031-2032	2033-2034	2035-2036	2037-2038	2039-2040	2041-2042	2043-2044	2045-2046	2047-2048	2049-2050	2051-2052	2053-2054	2055-2056	2057-2058	2059-2060	2061-2062	2063-2064	2065-2066	2067-2068	2069-2070	2071-2072	2073-2074	2075-2076	2077-2078	2079-2080	2081-2082	2083-2084	2085-2086	2087-2088	2089-2090	2091-2092	2093-2094	2095-2096	2097-2098	2099-2100	2101-2102	2103-2104	2105-2106	2107-2108	2109-2110	2111-2112	2113-2114	2115-2116	2117-2118	2119-2120	2121-2122	2123-2124	2125-2126	2127-2128	2129-2130	2131-2132	2133-2134	2135-2136	2137-2138	2139-2140	2141-2142	2143-2144	2145-2146	2147-2148	2149-2150	2151-2152	2153-2154	2155-2156	2157-2158	2159-2160	2161-2162	2163-2164	2165-2166	2167-2168	2169-2170	2171-2172	2173-2174	2175-2176	2177-2178	2179-2180	2181-2182	2183-2184	2185-2186	2187-2188	2189-2190	2191-2192	2193-2194	2195-2196	2197-2198	2199-2200	2201-2202	2203-2204	2205-2206	2207-2208	2209-2210	2211-2212	2213-2214	2215-2216	2217-2218	2219-2220	2221-2222	2223-2224	2225-2226	2227-2228	2229-2230	2231-2232	2233-2234	2235-2236	2237-2238	2239-2240	2241-2242	2243-2244	2245-2246	2247-2248	2249-2250	2251-2252	2253-2254	2255-2256	2257-2258	2259-2260	2261-2262	2263-2264	2265-2266	2267-2268	2269-2270	2271-2272	2273-2274	2275-2276	2277-2278	2279-2280	2281-2282	2283-2284	2285-2286	2287-2288	2289-2290	2291-2292	2293-2294	2295-2296	2297-2298	2299-2300	2301-2302	2303-2304	2305-2306	2307-2308	2309-2310	2311-2312	2313-2314	2315-2316	2317-2318	2319-2320	2321-2322	2323-2324	2325-2326	2327-2328	2329-2330	2331-2332	2333-2334	2335-2336	2337-2338	2339-2340	2341-2342	2343-2344	2345-2346	2347-2348	2349-2350	2351-2352	2353-2354	2355-2356	2357-2358	2359-2360	2361-2362	2363-2364	2365-2366	2367-2368	2369-2370	2371-2372	2373-2374	2375-2376	2377-2378	2379-2380	2381-2382	2383-2384	2385-2386	2387-2388	2389-2390	2391-2392	2393-2394	2395-2396	2397-2398	2399-2400	2401-2402	2403-2404	2405-2406	2407-2408	2409-2410	2411-2412	2413-2414	2415-2416	2417-2418	2419-2420	2421-2422	2423-2424	2425-2426	2427-2428	2429-2430	2431-2432	2433-2434	2435-2436	2437-2438	2439-2440	2441-2442	2443-2444	2445-2446	2447-2448	2449-2450	2451-2452	2453-2454	2455-2456	2457-2458	2459-2460	2461-2462	2463-2464	2465-2466	2467-2468	2469-2470	2471-2472	2473-2474	2475-2476	2477-2478	2479-2480	2481-2482	2483-2484	2485-2486	2487-2488	2489-2490	2491-2492	2493-2494	2495-2496	2497-2498	2499-2500	2501-2502	2503-2504	2505-2506	2507-2508	2509-2510	2511-2512	2513-2514	2515-2516	2517-2518	2519-2520	2521-2522	2523-2524	2525-2526	2527-2528	2529-2530	2531-2532	2533-2534	2535-2536	2537-2538	2539-2540	2541-2542	2543-2544	2545-2546	2547-2548	2549-2550	2551-2552	2553-2554	2555-2556	2557-2558	2559-2560	2561-2562	2563-2564	2565-2566	2567-2568	2569-2570	2571-2572	2573-2574	2575-2576	2577-2578	2579-2580	2581-2582	2583-2584	2585-2586	2587-2588	2589-2590	2591-2592	2593-2594	2595-2596	2597-2598	2599-2600	2601-2602	2603-2604	2605-2606	2607-2608	2609-2610	2611-2612	2613-2614	2615-2616	2617-2618	2619-2620	2621-2622	2623-2624	2625-2626	2627-2628	2629-2630	2631-2632	2633-2634	2635-2636	2637-2638	2639-2640	2641-2642	2643-2644	2645-2646	2647-2648	2649-2650	2651-2652	2653-2654	2655-2656	2657-2658	2659-2660	2661-2662	2663-2664	2665-2666	2667-2668	2669-2670	2671-2672	2673-2674	2675-2676	2677-2678	2679-2680	2681-2682	2683-2684	2685-2686	2687-2688	2689-2690	2691-2692	2693-2694	2695-2696	2697-2698	2699-2700	2701-2702	2703-2704	2705-2706	2707-2708	2709-2710	2711-2712	2713-2714	2715-2716	2717-2718	2719-2720	2721-2722	2723-2724	2725-2726	2727-2728	2729-2730	2731-2732	2733-2734	2735-2736	2737-2738	2739-2740	2741-2742	2743-2744	2745-2746	2747-2748	2749-2750	2751-2752	2753-2754	2755-2756	2757-2758	2759-2760	2761-2762	2763-2764	2765-2766	2767-2768	2769-2770	2771-2772	2773-2774	2775-2776	2777-2778	2779-2780	2781-2782	2783-2784	2785-2786	2787-2788	2789-2790	2791-2792	2793-2794	2795-2796	2797-2798	2799-2800	2801-2802	2803-2804	2805-2806	2807-2808	2809-2810	2811-2812	2813-2814	2815-2816	2817-2818	2819-2820	2821-2822	2823-2824	2825-2826	2827-2828	2829-2830	2831-2832	2833-2834	2835-2836	2837-2838	2839-2840	2841-2842	2843-2844	2845-2846	2847-2848	2849-2850	2851-2852	2853-2854	2855-2856	2857-2858	2859-2860	2861-2862	2863-2864	2865-2866	2867-2868	2869-2870	2871-2872	2873-2874	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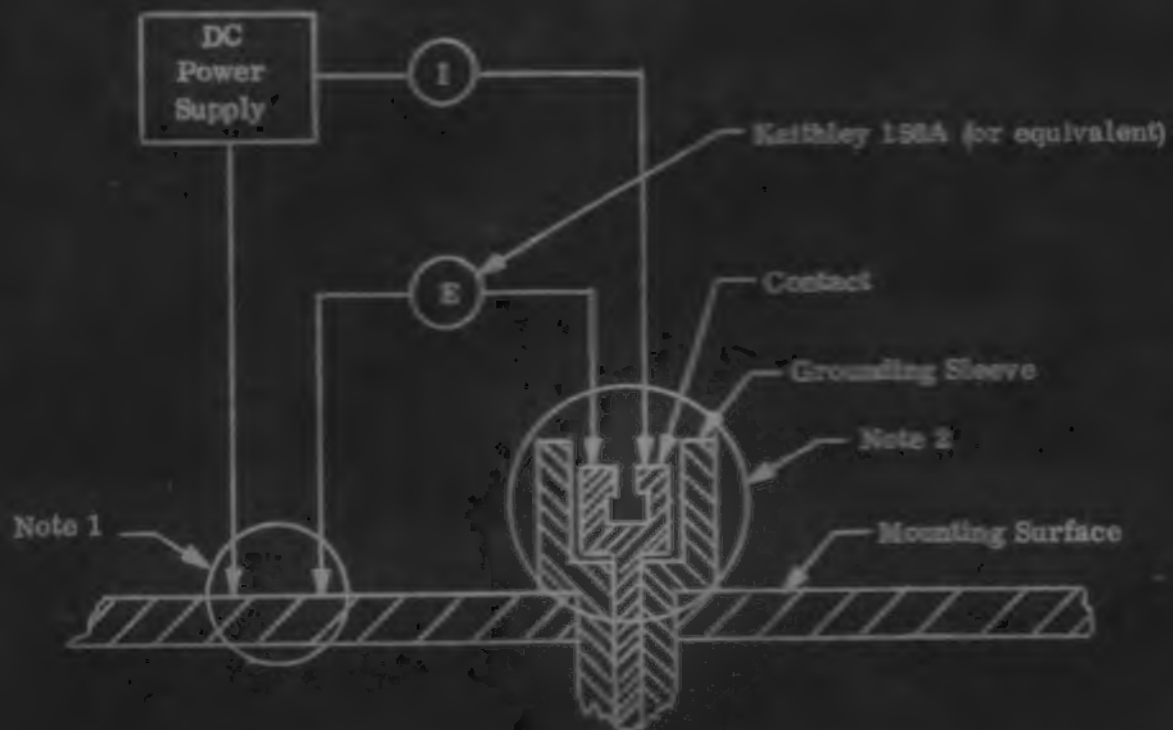


OF CONTACTS



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Note 1: Connections to be made at separate points on an uncoated surface.

Note 2: Connection to be made using a two section simulated male pin which provides electrical isolation between the supply and voltmeter leads.

GROUNDING PIN RESISTANCE MEASUREMENT

FIGURE 7

APPENDIX I

1. PURPOSE

1.1 The purpose of this appendix is to establish a repair procedure for the replacement of connectors damaged beyond functional useability as determined by supplier's Quality Control.

1.2 Replacement of insulator-contact assemblies

1.2.1 Remove damaged insulator-contact assembly with suitable extraction tool approved by the supplier's Quality Control.

1.2.2 Inspect hole for dimensions and damage. The hole must meet the requirements of the applicable drawing. This shall include touch-up as necessary to the protective coating.

1.2.3 Condition the insulator per 3.4.1 or precondition 1010956 insulator by submerging in distilled water for 24 hours, then remove from water and store in 60 percent \pm 15 percent R.H. chamber for a minimum of 48 hours in open container prior to installation at a temperature of $25^{\circ} \pm 5^{\circ}\text{C}$, and install the insulator-contact assembly with suitable tool approved by the supplier's Quality Control.

1.2.4 Inspect replaced connector for dimensional requirements per 3.3.4, for bent contact per 3.4.2, for workmanship per 3.4.4, for contact insertion per 3.3.2 and for contact withdrawal per 3.3.3. For push-out load 5 samples shall be fabricated, for each type of connector assembly repaired, once each month or once every 1,000 pins repaired whichever comes first. The supplier's quality control group is responsible for this action for purposes of equipment recalibration.

1.3 Replacement of Ground Sleeve-contact assemblies

1.3.1 Remove damaged grounding sleeve-contact assembly using suitable tooling approved by the supplier's Quality Control.

1.3.2 Inspect hole for deformation. Deformation shall be defined as damage which would prevent installation of a grounding sleeve-contact assembly from meeting requirements of this specification. Marring or indentations caused by the knurled portion of the original grounding sleeve shall not be cause for rejection.

1.3.3 Measure hole to determine size of ground sleeve required for replacement. Ground sleeve replacement must have a minimum interference fit with mounting hole of 0.0005.

1.3.4 Install grounding sleeve-contact assembly using suitable tooling approved by the supplier's Quality Control.

1.3.5 Inspect assembled connector for dimensional requirements per 3.3.4, for bent contact per 3.4.2, for workmanship per 3.4.4, for contact insertion per 3.3.2 and for contact withdrawal per 3.3.3.

